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ISSUANCES

of the

Meat and Poultry Inspection Program

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Change 80-7, Meat and Poultry
Inspection Manual

UNITED STATES DEPARTMENT OF AGRICULTURE
Food Safety and Quality Service
Meat and Poultry Inspection Program
Washington, D.C. 20250



UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND QUALITY SERVICE
MEAT AND POULTRY INSPECTION PROGRAM
WASHINGTON, D.C. 20250

Meat and Poultry Inspection Manual

JULY 1980

CHANGE: 80-7

MAINTENANCE INSTRUCTIONS

| Remove Page | Insert Page | Numbered |
|-----------------------------|--------------------------------|----------|
| 258 and 259, 259a, and 259b | 258, 258a, 259, 259a, and 259b | 80-7 |
| 261-1 through 261o | 261-1 through 261o | |

Pen-and-Ink Changes

1. Page 37, section 8.43, 3, line 3, add the phrase "time weighted value" between the words "the" and ".5 percent".
2. Page 237, section 22.24(b)(6)h, line 2, remove the words "prime steam".
3. Page 259c, section 22.39(b)(3), line 1, add the following sentence after the words "Inedible products". "Inedible products can originate in any USDA plant."

Bulletins Deleted

Changes in pages 258 through 259b cancel MPI Bulletins 79-116 and 80-13.

for the Importation of Beef and Pork and of Products Manufactured from such Meat," is signed by an MPI veterinarian, the title "Veterinary Officer" should be crossed out, and if signed by a military veterinary officer, the title "Official Veterinarian" should be crossed out. All four copies of MP Form 62 should be signed individually and distributed the same as MP Form 412-3.

2. Poultry. Issue MP Forms 506 and 70. MP Form 70 is not required if the product has been heated to an internal temperature of at least 65° C. (149° F.), and this is so indicated on MP Form 506.

(2) Commercial shipments. When shipments by commercial firms to the military in West Germany (where product is held for sale only to the military) are made without DPSC Form 300, issue export certificates described in (b).

22.39 GREAT BRITAIN - UNITED KINGDOM

(a) Meat Products

Meat and meat food products, except those for U.S. military forces, must originate in MPI certified plants.

(1) Plant approval. Plants, including horsemeat plants, desiring to export to the United Kingdom (UK) must meet the requirements of this section and submit an application (MP Form 31) through RD to the Deputy Administrator.

- * (i) Facilities and equipment. Sep-
- * arate rooms are required for emptying
- * and cleaning stomachs and intestines,
- * and the further handling of stomachs
- * and intestines, apart from other
- * slaughterhouse operations. Other
- * offal operations, i.e., spotting or
- * chilling of livers, shall not be per-
- * formed in the separate rooms described
- * above.
- * Wooden pallets may not be used near
- * or for exposed product.

(ii) Water supply. In canneries, a bacteriological examination of the water supply must be done monthly; in other plants, more frequently than once yearly for municipal water and more frequently than twice yearly for well water.

(iii) Clothing. Employees handling edible product or working in edible product areas must wear suitable protective clothing, including head covering and footwear (with rubber or plastic soles), capable of being cleaned and kept clean. Street clothing is not permitted.

(iv) Canning. Seams of can ends should be routinely checked. Hydrostatic retorts must be cleaned as necessary and replacement water must be added to cooling water reservoirs to prevent buildup of organic material. Can cooling water should be checked periodically and kept clean. The level of available chlorine in this water should not fall below .5 ppm and should be checked frequently. After retorting, cans should be cooled and thoroughly dry before manually handled. All can handling equipment must be easily cleaned.

(2) Eligible product; certification. It is the responsibility of the importer to assure that products meet the compositional standards expressed in the British "Sausage or Other Regulations 1967."

All certificates and supplementary statements must be signed by an MPI veterinarian. A copy of the certificates, MP Form 412-3 or MP Form 414-3, must be attached to and remain with the original certificates. Certain federally inspected plants are approved by VS for immediate slaughter of cattle, sheep, and swine from Canada, and for cattle and sheep from Mexico. Meat and byproducts produced in such plants should not be certified for export to UK unless arrangements, satis-

Food, and the Secretary of State for Scotland in accordance with the provisions of the Imported Food Regulations 1968 (or the Imported Food (Scotland) Regulations 1968)."

(iii) **Canned.** Shelf-stable canned product from all species, packed in hermetically sealed metal or glass containers, may also be exported. Issue MP Form 412-3.

(iv) Product for U.S. military forces. Certification requirements are the same as for commercial shipments.

(v) "Papain" kidneys. When they are to be shipped for edible purposes, they must be (1) from federally inspected carcasses, (2) handled as edible product, (3) kept identified, and (4) packed in containers labeled "Beef Kidneys - Tendered with Papain--For Export Only."

(vi) **Casings.** They must:

1. Originate from animals slaughtered in plants certified for export to the UK and the establishments which process the casings must also be certified for export to the UK.

2. Be accompanied by a declaration on USDA letterhead stationery signed by an authorized veterinary officer stating that the casings were cleaned and scraped.

3. Be identified by approved label with inspection legend including an establishment number in the 3,000 series (Food Inspection Service.)

4. Upon exporter's request be accompanied by MP Form 415-5.

In order to comply with the UK requirements, plants wishing to export casings to the UK will have to apply for (Food Inspection Service), and also request that the establishment

* number in the 3,000 series be certified for export to the UK. Establishments which also handle casings originating from plants other than those certified for export to the UK must establish a means of identification, segregation and record keeping to assure the inspector that the casings destined to the UK are in fact derived from animals slaughtered in plants certified for export to the UK.

(vii) Fats, oils.

1. Certification. Issue MP Form 412-3. Original must accompany shipments. Shipments arriving without certificate will be refused entry. Include the following on the export certificate:

a. Location of tanks. For example, Port #3 or Starboard #2 shall be shown in the space for "Shipping Marks" and "Stamp Numbers." Tanks shall be identified again in the "No. Column" as P-3 or S-2.

b. For each tank, the estimated product weight shall be listed in the weight column. Such weight may be obtained from marine surveyor.

* c. A statement of cleanliness should be made in the description column to read: "The pipes and pumps used for loading lard or fat and the tanks were inspected and found to be clean before the lard or fat was loaded."

2. Requirements:

a. Ship tanks. They will be inspected and passed for cleanliness before product is loaded onto the ship. Marine surveyors will do this inspection under general inspector's supervision. To be acceptable, tanks must be clean, dry, and free of residues from previous cargoes.

b. Product from I.D. Service. When product is shipped from an Identification (ID) Service place, an inventory of federally inspected lard or rendered fats will be maintained. Records will include additions to and removals from each storage tank.

Inspector should be able to estimate product amount in storage at any time. An inspection opening is required on each tank. Transfer from tank to ship is permitted only through a line without other connections than to the tank. Product transfer may also be accomplished by use of tank trucks. Ship tanks shall be examined to assure they are empty before operations start. Loading will be done under continuous supervision of the inspector. If operations are interrupted for any reason, the hatch on the tank must be sealed. The seal must not be broken until operations are resumed.

c. Label. Approved label(s) bearing printed inspection legend with establishment number (317.2) will be attached to the export certificate. Establishment number will be in the 3,000 series for product shipped from an ID Service installation. One export stamp will be issued for each ship's tank. Stamps shall be attached to all hatches of filled tanks. Original export certificate and attached label(s) shall be delivered to the shipper, who shall deliver them to the chief officer of the vessel carrying the shipment. The chief officer shall present the certificate and label(s) to the port health authority on arrival in UK.

d. Antioxidants. Edible fats and oils may contain antioxidants in the following amounts:

| | | |
|---------------------------------|-----------------------|---------|
| Propyl gallate, | octylgallate, | |
| dodecylgallate, | or any mixture of the | |
| three----- | | 100 ppm |
| Butylated hydroxyanisole (BHA)- | | 200 ppm |
| Butylated hydroxytoluene (BHT)- | | 200 ppm |
| Any mixture of BHA and BHT----- | | 200 ppm |
| Citric Acid----- | | 100 ppm |

When product contains antioxidants, the label must include a description of antioxidants, and maximum amount expressed in parts per million.

(3) Marking, labeling. UK recognizes the Federal meat inspection legend, with establishment number of

producing plant, as being the "official certificate" for importation of product from the United States. Such legend must be as required by regulations (312.2), and must be affixed to all shipping cartons and packages of meat or meat products. For large containerized shipments (vans), it must be attached to the container. If the container holds product from more than one plant, it must bear an inspection legend from each official plant represented by the product inside. Legend or product label with inspection legend may be applied to containers at places outside official plants by using ID Service (R).

To comply with regulations (322.4), issue MP Form 412-3 and mark outside containers as required by Section 312.8 of the regulations.

(4) Prohibited importation. The following importations are prohibited:

a. Scrap meat. Meat consisting of scraps, trimmings, or other pieces (with or without bone) of such shape or in such condition as to afford insufficient means of identification with a definite part of a carcass.

b. Any carcass part chopped or minced with or without spices, cereal products, salt, flavoring, vegetables, or other ingredients.

Exception: Beef patties, flake steaks, fresh beef or pork sausage, etc., may be shipped to the military.

c. Heads without submaxillary lymph nodes.

d. Livers without hepatic lymph nodes. These nodes must be incised and left attached to the livers. Livers not meeting this requirement will be rejected.

e. Boneless meat from calves less than 3 months old.

(5) Ports of Entry. Fresh, chilled, or frozen meats or byproducts may enter UK only through the following ports: Avonmouth, Cardiff, Dover (Eastern Docks), Felixstowe, Folk-

stone, Great Yarmouth, Grimsby, Harwich, Liverpool, London (Royal Group), London (Tilbury), Newhaven, Plymouth, Sheerness, Southampton, and Tyne (North Shields).

Processed or canned products are permitted entry at all ports.

(b) Poultry Products

(1) Plant approval. Federally inspected plants desiring to export other than cooked poultry products to the UK must submit an application (MP Form 31) to RD. In certifying such plants, RD will ascertain that the requirements of EEC Directives 71-118 and 78-50 are fulfilled.

(2) Eligible product; certification.

(i) Fresh poultry. The definition of "fresh poultry" for UK includes frozen carcasses and cut-up poultry, and giblets. Carcasses must be fully eviscerated and not contain or be accompanied by any offal (necks and giblets).

Exports of poultry other than cooked must meet the requirements in the European Economic Community (EEC) Directive 71/118, and must originate in MPI certified plants. Those for use by U.S. forces can originate in any official poultry plant, but must be accompanied by MP Form 506, MP Form 412-14, and MP Form 40, which are also required for commercial shipments.

The official poultry inspection legend will fulfill the "health marking" requirements (Item 30, Chapter VII, EEC Directive 71/118). The official legend must be applied to the poultry carcasses which are not individually wrapped or to wrappers or visibly beneath wrappers of poultry carcasses which are individually wrapped and to wrappers or visibly beneath wrappers of parts of poultry or poultry offal packed in small quantities as well as to any package in which any of the foregoing are packed.

Poultry carcasses packed in bulk which are sealed by a label bearing

* the official inspection legend are
 * exempt from the requirements,
 * immediately above, provided that they
 * are destined for further processing in
 * the UK, and the label indicates the
 * intended use. For example:

*
 * _____
 * INTENDED USE-CUTTING
 *
 *
 * Address of destination:
 *
 *
 *
 * _____
 *
 *

* Parts of poultry carcasses which are
 * packed in bulk (i.e., fifty drumsticks
 * without any wrappers packed into one
 * large container) need only one inspec-
 * tion legend which is placed on the
 * outside of the shipping container.

Under conditions outlined on MP Form 412-14, item (b), official establishments and/ or flock, management will be required to furnish written certification by their veterinarian attesting compliance with requirements regarding health of originating flock. This serves as basis for certification required of the official veterinarian at slaughtering establishment (MP Form 412-14). The following additional statement shall appear on MP Form 412-14 above the official veterinarian's signature: "The whole of the consignment described above was derived from poultry which were hatched, reared, and slaughtered in a State in which, after due inquiry, I am satisfied that an outbreak of a velogenic strain of Newcastle Disease has not been recorded in the past 6 months." The MPI veterinarian will substantiate the official status of disease in areas by conferring with responsible VS officials.

(ii) Cooked/canned poultry. Exports

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that received ante- and post-mortem inspection and were found free of disease at time of slaughter."

Undenuded rumen pillars may be exported, provided they are:

1. From carcasses passed for human food.
2. Collected immediately after emptying rumen of loose contents.
3. Characteristically inedible by natural appearance or by the application of powdered charcoal.
4. Labeled "Inedible (species) Rumen Pillars" and include (1) packer's name, address, and establishment number without official inspection legend, (2) net weight (in pounds), (3) "keep frozen," or "keep refrigerated," as applicable, and (4) "For Export to South Korea."

22.55 LEBANON

Meat Products

Processed products shall bear manufacture date on immediate container. If coded, explain each code on export certificate.

22.56 LIBYA

Poultry Products

Issue MP Form 506 for frozen poultry. Sanitary certificates will be prepared by regional office, and returned to the supervisor for distribution (see France).

22.57 LUXEMBOURG

Meat Products

Issue MP Form 412-3.

Byproduct. Byproducts such as livers must individually bear marks of inspection.

22.58 MALAYSIA

(a) Meat Products

(1) Certification. MP Form 412-3 shall be accompanied by a veterinary certificate on USDA letterhead stating:

a. The country was free from foot-and-mouth disease and rinderpest for 12 months immediately before slaughter of animals from which products were derived.

b. Meat or meat food products derived from animals subjected to ante- and post-mortem examinations and were free from infectious and contagious disease; products for export to Malaysia are fit for human consumption; and every precaution has been taken to prevent contamination before export.

c. In case of pork or pork products, a further veterinary statement is required certifying that the country or district was free of swine fever (hog cholera) during the past 6 months. "District" has been interpreted to mean a State or county. This statement is not required for canned pork products or lard.

d. A veterinarian must sign all certificates (followed by his degree, such as D.V.M.). The signature must be impressed with the official seal of the United States Department of Agriculture, Meat and Poultry Inspection Program.

(2) Permit. An import permit is required from the State veterinary officer permitting the importation of such product into Malaysia.

(b) Poultry Products

(1) Fresh/frozen. For all poultry, the MP Form 506 shall be signed by an MPI veterinarian and contain the following statement: "The (poultry) products were derived from (poultry) subject to ante- and post-mortem examinations and have been found to be free from infectious and contagious disease. The (poultry) products are fit for human consumption, and every precaution has been taken to prevent contamination prior to export. Foot and mouth disease has not existed since 1929, and rinderpest has never existed in the United States."

- * (2) Cooked. Only hermetically
- * canned cooked poultry may be exported
- * without the certification statement
- * specified immediately above.

22.59 MALTA

Poultry Products

Issue MP Form 506 without additional statements for all shipments.

22.60 MARTINIQUE

Exports to Martinique, French West Indies, must meet the same requirements as those destined to France. However, when codes are used in lieu of actual dates on cartons or cans of product to be sold at retail or institutional levels, the exporter must furnish such codes in advance to the Director des Veterinaires, Direction Departmental de L'Agriculture, Boulevard General Charles de Gaulle, Fort-de-France, Martinique.

22.61 MEXICO

Meat Products

Five copies of the export certificate are required. The fifth copy should be a photostat of the original.

Unscalded stomachs. See 22.17(b).

22.62 MONACO

Monaco is considered to be part of French territory. Therefore, all sanitary and customs regulations for Monaco are the same as for France.

22.63 NETHERLANDS

(a) Meat Products

Issue MP Form 124 for fresh/frozen meat and MP Form 412-9 for processed meat food products.

(1) Fresh product. The following fresh and frozen products from animals slaughtered in USA are eligible for entry:

a. Beef cuts, with or without bone, weighing at least 6.6 pounds. Individual cuts weighing a minimum of 6.6 pounds are permitted only on air freight shipments not exceeding 3,000 pounds.

b. Beef tails and beef or horsemeat tenderloins of any weight.

c. Pork bellies, ham, shoulders, and loins.

d. Fresh lamb, mutton, or horsemeat, individual cuts weighing not less than 6.6 pounds.

e. Byproducts--livers, kidneys, tongues, stomachs (without mucous membrane; no omasa), intestines, brains, hearts, spleens, cleaned gullets, ears, feet, thymus, and pancreas.

(2) Inspection marks. Livers of all species must be branded with hot iron.

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Individual meat cuts and heads of all species, hearts and tongues of cattle and horses, and pork jowls must be marked with legible ink or hot iron stamp. Marks of inspection are not required on kidneys, tails, and gullets of all species and on hearts and tongues of swine, sheep, goats, and calves (cattle less than 3 months old).

NOTE: Shipments of product not marked as required will be refused entry. Export certificate requests for product which should but does not bear brands must be denied. Such shipments "at exporter's risk" are not permitted.

(3) Inspection procedures.

a. Livers. Beef and sheep livers shall be inspected as follows:

1. Open bile duct by usual method.
2. Make a transverse incision not longer than 2 inches and approximately 3/4 inches deep across the omasal impression of the liver visceral surface, cutting the smaller branches of the bile duct.

3. Make a second transverse incision not longer than 2 inches and approximately 3/4 inches deep across the liver visceral surface from beside and below the caudate lobe, cutting only the smaller branches of the bile duct.

b. Kidneys, bladder. They should be examined. Renal lymph nodes should also be incised. Carcasses with kidneys and/or kidney fat removed are acceptable.

* (4) *Trichinae* certification. For
 * product containing pork muscle tissue,
 * the following statement must appear
 * below the health certificate
 * (Block IV) on MP Form 124 and MP Form
 * 412-9: "The pork described above
 * (check one) has been/___/--has not
 * been/___/ frozen according to Dutch
 * Government specifications."

The Dutch requirements for the refrigeration treatment of pork for trichinae are the same as those specified for West Germany. See the six items specified under section 22.38(c)(1) (iii). (The temperature requirement has changed from -15° C. to -25° C. (-13° F.)).

Heating the pork to an internal temperature of at least 80° C. (176° F.) is still an acceptable means of trichinae treatment.

(5) Rendered fats; antioxidants.

The following antioxidants may be added to rendered animal fats or to combinations of rendered animal fats and vegetable fats: dodecylgallate, propylgallate and octylgallate, not more than 0.01 percent either singly or in combination.

Note: Dodecylgallate and octylgallate are not listed in the regulations (318.7), but may be used for export only (318.8).

Certification. Besides MP Form 412-3, an MPI veterinarian shall complete a certificate in the following form:

"The undersigned (name and title of the authorized veterinary officer in the country of origin), at _____, certifies: that the edible rendered fats packed in (description of packing), gross weight _____, net weight _____, and marked as follows--(name of product), forwarded from (place of dispatch) by (name and address of shipper) and destined for (name and address of consignee) forwarded by (manner of forwarding, name of ship when shipped), were derived from slaughtering animals of the type as defined in the (Dutch) Meat Inspection Act, which were subject to ante- and post-mortem inspection and were found to be entirely sound and fit for human consumption; that, insofar as they contain common salt, they only contain it in very small quantities;

that no preservatives have been used other than propylgallate and/or octylgallate and/or dodecylgallate, and that the total contents of these gallates do not amount to more than 0.01 percent; that they are free from all other substances foreign to animal fats and oils; that the composition is in conformity with the view of the mark stated; that the composition in no respect is in contravention of the purport of this certificate."

Given at _____, on
_____.

(Signature)

(6) **Meat animals.** These animals, as defined in the Dutch Meat Inspection Act, are horses, cattle, sheep, goats, and swine.

If the rendered animal fats being exported are derived from horses, regular export stamps and certificates will not be used.

(7) **Casings.** Issue MP Form 413.

(8) **Product not for human food.** Inedible products are not eligible for importation into the Netherlands.

Calf stomachs, rennet, and other edible byproducts or organs intended for pharmaceutical use in a Dutch plant may be shipped as inedible, without U.S. inspection legend and without being denatured, provided they are properly identified. Issue MP Form 415-3 and a statement on reverse of form or on USDA/FSQS stationery certifying that the product (1) is derived from unconditionally approved animals that were slaughtered at Est. (number), inspected and found wholesome, and (2) is consigned for pharmaceutical use only.

Shipping containers must be prominently marked "(Product's name) For Pharmaceutical Use - For Export to the Netherlands."

(b) Poultry Products

(1) **Plant Approval.** Plants desiring to export fresh frozen poultry to the Netherlands must meet EEC requirements and submit MP Form 31. In certifying such plants, RD will apply the same criteria used in certifying poultry plants for slaughter/cut-up which export poultry to West Germany. (Those establishments are certified as meeting EEC requirements). Poultry products other than fresh poultry may be exported from any U.S. poultry plant under Federal inspection.

(2) **Certification.** Each shipment must be accompanied by an MP Form 506 bearing the following statement: "The poultry products covered by this certificate came from birds recognized as being healthy prior to slaughter. The product is wholesome, fit for consumption, and from birds that have not been treated with estrogens for either therapeutic or zootechnic purposes."

With the exception of sterile canned poultry product (in jars or cans), all processed poultry product must be additionally certified on MP Form 506 as follows: "I certify that the product described herein has been heated to at least 65° C. (149° F.)."

22.64 NETHERLANDS ANTILLES

Issue MP Form 412-3 for meat and MP Form 506 for poultry.

22.65 NEW CALEDONIA

Meat Products

Issue MP Form 412-3 with the following statement typed on the reverse:

"I further certify that in accordance with official declaration by the Veterinary Services of the U.S. Department of Agriculture, the United States is free from rinderpest (bovine pest), contagious bovine pleuropneumonia, foot-and-mouth disease (aphthous fever), and hog cholera (pork pest)."

The export certificate and the

UNITED STATES DEPARTMENT OF AGRICULTURE
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